

PATENT  
DP-305919

Claims 1-12 (canceled herein)

Claim 13 (previously presented): A method for making a ball-nut assembly comprising the steps of:

a) obtaining a ball nut including a radial through slot and including an outer surface having a first portion, having a ledge radially recessed from the first portion and at least partially bounding the through slot, and having an undercut wall connecting the ledge and the first portion;

b) obtaining a crossover member having a flange and a crossover-grooved portion, wherein the crossover portion includes at least one crossover groove;

c) disposing the crossover member from outside the ball nut to have the flange supported against radially-inward movement by the ledge and the crossover-grooved portion disposed in the through slot with every part of every crossover groove of the crossover-grooved portion disposed radially inward of the ledge; and

d) after step c), transversely and ductilely elongating the flange creating a staked portion of the flange which contacts the undercut wall of the outer surface of the ball nut.

Claim 14 (previously presented): A method for making a ball-nut assembly comprising the steps of:

a) obtaining a ball nut including a radial through slot and including an outer surface having a first portion, having a ledge radially recessed from the first portion and at least partially bounding the through slot, and having an undercut wall connecting the ledge and the first portion;

b) obtaining a crossover member having a flange and a crossover-grooved portion;

c) disposing the crossover member from outside the ball nut to have the flange supported by the ledge and the crossover-grooved portion disposed in the through slot;

d) deforming the flange creating a staked portion of the flange which contacts the undercut wall of the outer surface of the ball nut; and

e) after step a) and before step c), aligning the ball nut on a locating arbor which simulates balls placed around a ball screw.

PATENT  
DP-305919

Claim 15 (original): The method of claim 14, wherein step c) includes aligning the crossover member on the locating arbor.

Claim 16 (original): The method of claim 15, also including between steps c) and d) the step of checking the radial position of the crossover member with a position indicator.

Claim 17 (original): The method of claim 15, also including between steps c) and d) the step of clamping the crossover member against the locating arbor.

Claim 18 (original): The method of claim 15, wherein step d) includes using a stake punch.

[THIS SPACE IS INTENTIONALLY BLANK]